Work Orde		1742 2:58:21 PM	D3451-		*111	1742*						Page 1
	D3451-041		b i i · · ·		Accept	*N900	0//	100	ገ* ያ	Setup Sta	rt *NI	C1*
Revision ID:						14.5/1//	,,,,,				1.7	
Item Name:	Handle And I	ock-Down Assen	ıbly							Sto	_b *N	S2*
Start Date:	1/20/2014	Start Qty: 5	5.00	*5*		Cust Item 1	ID:	ź				
Required Date:	1/31/2014	Req'd Qty: 5	00.	*5*		Customer:	;					
Reference:				• •								
Approvals:	Process Pla	an:	Date: 1	1-1-20	- Tooling:	D	ate:		F	Run Sta	^ <i>\</i>	R1*
	QC:		Date:		_ SPC (Y/N):	D	ate:			Sto	_b *N	R2*
Sequence ID/ Work Center II	0	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr							<u> </u>			
D3451	Rev	' A										
100		η.			0.00		.//-					N
100 Large Fab		Large Fab Men			0.00				_5_	<u>Ø</u>	<u>.</u>	1 2
Large Fab			l as per dwg PB67-43	3001						,		14.01.20
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110		QC9- Inspect visi	ıal per QSI004- Fusio	on Welds	0.00							DAS
*11 0 *		Men	10		0.00				_(5)_	14.0	131	9 9-89
Quality Control		Wen										سة **-
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		QC3- mspect par	completeness to ste	μοιι w/O	0.00				(-1	١.		9 9-89
120 oc		Mon	20		0.00				(5)	14.0	131	

Quality Control

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / L				_	AEROSPACE
QA Closed:			Date:					-			Wo	rk Order up	date only	<u> </u>
Work Orde	er:					DISPOSITION		:		AGAINST	DEP	ARTMENT	PROCESS	
	•					Rework	1		Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1 1	Thern	noforming	Finishing	╗	Rec/Stor	e/Packaging	Other
NCR N	10.					Suspected Unapproved]		Large Fab	Composite			Supplier	
									,				•	· · · · · · · · · · · · · · · · · · ·
Root					Desc	ription of work order update		nitial		ction	İ	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	_	Date	Verification	QC Inspector
Design											١			
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Equip/Tooling						•								
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Offset/Setup														
Process							ļ							
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Landi	ng (Gear				General	•••							-
	_	Bending				Bend		Folio/F	Program	Į.		Outside Dim	ensions Γ	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	\vdash	Grain			$\boldsymbol{\vdash}$	Over/Under	<u> </u>	Set-up
	Cracks Broken/Damage/Defect Hardware								-	Part Incorred	<u> </u>	Temperature/Cure		
		Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified							Jnqualified		Part Lost/Mi	ssing	Weld	
						tions Incomplete,	· .		Part Moved		Wrong Stock Pulled			
	Crushing Countersink Misaligned/off								Positioned V	Vrong	-			
		Heat Trea	it			Cut Too Short		Mislab				Power Loss/	Surge	Other
	Inspection Strip in Tube Drawing				Misread									
	Marks/Chatter Drill Holes				Off-set									
	Turning Sequence Finish				Out of Calibration									
Wave/Twist in Tube Fit/Functio					Fit/Function	Out of Sequence								

W	ork	Order	ID	111742
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Quality Control

111742

Page 2

Monday, January 20, 2014 3:58:21 PM Item ID: D3451-041 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Handle And Lock-Down Assembly **Start Date:** Start Oty: 5.00 1/20/2014 **Cust Item ID:** Required Date: 1/31/2014 Req'd Qty: 5.00 **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Tool ID Plan Reject Reject Accept Insp. Work Center ID **Description** Qty **Run Hours** Code Qty Number Stamp 130 Chemical Conversion Coat per QSI005 4.1 0.00 DAS *130* HandFinish 0.00 Memo Hand Finishing Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 140 0.00 5 & H-2-3 *140* Powdercoat Memo Powder Coating 150 QC3- Inspect Part Finish 0.00 DAS 30 9-89 0.00 Memo

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDA	ATE			AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only		
Work Order	r:					DISPOSITION			A	AGAINST DE	PARTMENT	PROCESS		
Work Orac.	· –				-	Rework	1		Skid-tube Cr	rosstube]	Water Jet	Engineering	
Part No	o.					Scrap			⊢	mall Fab	Pro	d. Eng. Coor.	Quality	
	_					Use-as-is			Ŭ ⊢	Finishing	4	e/Packaging	Other	
NCR No	0.					Suspected Unapproved	1		~ —	mposite		Supplier	1 1	
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	on .	Date	Verification	QC Inspector	
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Handling/Pre	_													
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Operator														
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├	-	entre No	t Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain		<u> </u>	Over/Under	<u> </u>	Set-up	
1 -	_	racks			<u> </u>	Broken/Damage/Defect		Hardwa			Part Incorred	-	Temperature/Cure	
-		rimp/Kin	k/Ripple	/Wave	<u> </u>	Burrs		1 '	ion Incomplete/Unqual	<u> </u>	Part Lost/Mi	ssing	Weld	
	\dashv	uffs				Contamination		4	tions Incomplete/Uncle	ear	Part Moved		Wrong Stock Pulled	
-	—	rushing			<u> </u>	Countersink						Vrong	٦	
-	_	eat Treat				Cut Too Short					Power Loss/	Surge	Other	
-		spection	-	—				Misread						
-		1arks/Ch					Off-set							
Turning Sequence Finish					Out of Calibration									
Wave/Twist in Tube Fit/Function					Fit/Function	Out of Sequence								

Work Order ID	111742
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111742

Page 3

Monday, Januar	ry 20, 2014 3	2:58:21 PM												
Item ID: Revision ID:	D3451-041			Accept	*	N900	040	100)*	Setup		*N	S1*	=
Item Name:	Handle And L	ock-Down Assembly									Stop	*N	S2*	
Start Date:	1/20/2014	Start Qty: 5.00	*5*			Cust Item	ID:							
Required Date:	: 1/31/2014	Req'd Qty: 5.00	*5*			Customer:								
Reference:														
Approvals:	Process Pla	nn:	Date:	Tooling	g:	D	ate:		I	Run	Start	*N	R1*	
	QC:	_	_ Date:	_ SPC (Y	/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set U Run	Jp/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	_
160		Small Fab		0.00					(5)				FF 04-02	14
Small Fab		Мето		0.00					<u> </u>				09-02	7
Small Fab		1- assemble	rubber handle as per dwg	; PB67-43001	DAS 27 9-89									
170		QC5- Inspect part comp	leteness to step on W/O	0.00	4/2/4				5					
170		Memo		0.00	,					- —				
180 *180* Packaging Packaging		Identify as per dwg & S Memo	tock Location: <u>////</u> C	0.00					-5x	<u> </u>	· · · · · · · · · · · · · · · · · · ·	14-	2-4.	DA 21 9-1

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE		
QA Closed:			Date:							W	ork Order up	odate only			
Work Ord	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS			
	•					Rework			Skid-tube Crosstube]	Water Jet	Engineering		
Part f	No.					Scrap	Scrap Machining Small Fab						Quality		
NCR I	No.				<u></u>	Use-as-is Suspected Unapproved						Rec/Store/Packaging Other Supplier			
Root					Desc	ription of work order update	i	nitial	Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design															
Doc/Data	Ш						ļ								
Equip/Tooling	Tooling						1				·				
Handling/Pre	\vdash														
Material	\Box														
Operator	Щ														
Offset/Setup	Щ						Į								
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Supplier	Ш														
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							FA	ULT CA	TEGORY						
Landi	ng (1			_	General		1	_	_	1	. —	٦		
	<u> </u>	Bending			 	Bend		4	Program	<u> </u>	Outside Dim	 	Pressure/Forced		
		Centre No	ot Conce	ntric	<u> </u>	BOM/Route	\vdash	Grain		\vdash	Over/Under	<u> </u>	Set-up		
	<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect	\vdash	Hardwa		\vdash	Part Incorre	<u> </u>	Temperature/Cure		
ļ		1	imp/Kink/Ripple/Wave Burrs			\vdash	4	ion Incomplete/Unqualified	\vdash	Part Lost/M	issing	Weld			
	Cuffs Contamination				<u> </u>	4	tions Incomplete/Unclear	\vdash	Part Moved	_ _	Wrong Stock Pulled				
		Crushing			Countersink			4 '	gned/off center	-	Positioned V		٦٠		
	Heat Treat Cut Too Short				Mislabeled Power Loss/Surge Other				Jother						
	Inspection Strip in Tube Drawing				\vdash	Misrea									
	Marks/Chatter Drill Holes				Off-set										
	Turning Sequence Finish					Out of Calibration									
1	Wave/Twist in Tube Fit/Function						L	Out of	Sequence						

Work Ord Monday, Janua						Page	e 4						
Item ID: Revision ID: Item Name:	D3451-041 Handle And I	Lock-Down Assembly		Accept	*N900	<u>040</u>	100) * Se	tup Sta			S1*	
Start Date: Required Date Reference:	1/20/2014 :: 1/31/2014	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	ID:							
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		Ru		art op		R1* R2*	
Sequence ID/ Work Center I 190 *1 QA*	T D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Nı	eject umber	Insp. Stamp	
QC Quality Control		Мето		0.00			Ę	MLS				<u> </u>	_

190

Quality Control

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFOI	RMANCE / I		W۵	ork Order up	date only	\neg	AEROSPACE
QA Closed.			Date.										1		
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
	•					Rework			Skid-tube	Crosstube			Water Jet	٦	Engineering
Part i	No.			•		Scrap			Machining	Small Fab	$\boldsymbol{\vdash}$	Pro	d. Eng. Coor.	7	Quality
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NCR I	No.					Suspected Unapproved			Large Fab	Composite	\vdash	•	Supplier		
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Root					Desci	ription of work order update	ı	nitial	A	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	scription		Date	Verification	\perp	QC Inspector
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		Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain			\vdash	Over/Under	<u> -</u>	_	et-up
	_	Cracks			<u> </u>	Broken/Damage/Defect	\vdash	Hardwa			\vdash	Part Incorred	ļ	_	emperature/Cure
	Crimp/Kink/Ripple/Wave			<u> </u>	Burrs	\vdash	1 '	ion Incomplete/	•	-	Part Lost/Mi		_	Veld	
	Cuffs				Contamination	\vdash	4	tions Incomplete		-	Part Moved			Vrong Stock Pulled	
Crushing Countersink			•		-1	gned/off cente	er	\blacksquare	Positioned V		- .				
Heat Treat			Cut Too Short	<u></u>	Mislabe				Power Loss/	Surge [Ic	Other			
	\vdash	Inspection		Tube	<u> </u>	Drawing		Misrea							
				Drill Holes	Off-set										
	Turning Sequence				ļ	Finish	Out of Calibration								
	Wave/Twist in Tube				Fit/Function	Out of Sequence									

Monday, January 20, 2014 3:58:20 PM

Work Order ID:

111742

Parent Item:

D3451-041

Parent Item Name:

Handle And Lock-Down Assembly

Start Date: 1/20/2014

Required Date: 1/31/2014

Start Qty: 5.00

Required Qty: 5.00

Comments:

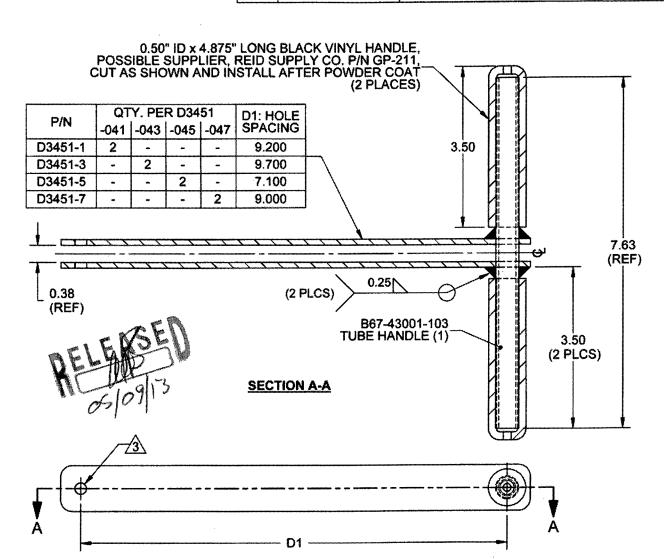
IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Issued Issued	Status
D3451-1		Manufactured	No			100	Each	11.0000	2	10	hui	- 1 011
Tube Handle Arm											114.0	21.24
				Location	11715	Loc Qty	<u>L</u>	oc Code		_		
				Mezz2	1715	11				<u>5</u>		
				104	4816	11				5		
GP-211		Purchased	No	-		100	Each	115.0000	2	10	FF OG	1-02 1
Rubber Handle									C		JP Of	7-029
				Location		Loc Oty	<u>L</u>	oc Code	•			
				ST283		15						
					3937	15						
				ST284		100						
DD (T. 40004-400				Μī	127975	100				10	ŃΙ	
PB67-43001-103 Tube Handle		Manufactured	No			100	Each	20.0000	1	5	14.01.	24
				Location		Loc Oty	<u>L</u>	oc Code				
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				525	570	4						
				Mezz2		16						
					0015	12						
				908	891	4						

DQA:		Date:										TRAGE	
						WORK ORDER NON	-CC	ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:								Nork Order u	odate only	
Work Orde	er:				:	DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	·
	•					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap]	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo.					Suspected Unapproved	J		Large Fab	Composite		Supplier	
Root	Ī				Desci	ription of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Doc/Data													
Equip/Tooling							l						
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Material											1		
Operator]						1					
Offset/Setup													
Process													
Supplier											- [
Training													
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		Bending			\vdash	Bend	-	4	Program	}	—	<u> </u>	Set-up
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						Broken/Damage/Defect	\vdash	Hardwa		Image alifical		 	Weld
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	Crushing Countersink Heat Treat Cut Too Short					Countersink	\vdash	-1	-				Other
Inspection Strip in Tube Drawing					Mislabeled Power Loss/Surge Misread				Totalet				
					Drill Holes	-	Off-set					· · · · · · · · · · · · · · · · · · ·	
	Turning Sequence Finish				-{	\vdash	4	Calibration					
				Fit/Function	\vdash	-1	Sequence			· · · · · · · · · · · · · · · · · · ·			
	Wave/Twist in Tube					p 19 f unicuon		Journ	sequence			· · · · · · · · · · · · · · · · · · · 	



	1				
DESIGN	\$	DRAWN	BY	1	OSPACE LTD ONTARIO, CANADA
CHECK		APPRO		DRAWING NO. D3451	REV. A SHEET 1 OF 2
DATE	05.0)8.25		TITLE HANDLE & LOCK	SCALE C-DOWN ASS'Y 1:2
 Α	0	5.08.25		NEW ISSUE	



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41 D3451-045 SUPERSEDES PREMIER P/N B67-43001-39 D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

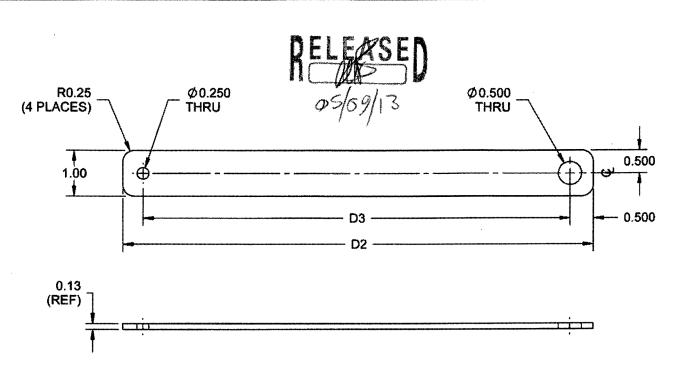
- 1) WELD PER DART QSI 004
- CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK BEFORE PAINTING.
- FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3 PART IS SYMETRICAL ABOUT CENTER LINE.
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES
- 6
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DQA:		Date:											A DT		
						WORK ORDER NON	-CC	ONFO	RMANCE / L	JPDATE					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde						DISPOSITION AGAINST DEPARTMENT/PROCESS						/PROCESS			
WOIK OIGE	-		•			Rework	Skid-tube Crosstube				Water Jet			Engineering	
Part N	l٥					Scrap	1		Machining	Small Fab	\dashv	Pro	d. Eng. Coor.	\dashv	Quality
· u.c.	-					Use-as-is	1 1	Therr	Finishing		Rec/Store/Packaging			Other	
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier			
	-					· · · ·]								—
Root					Desci	ription of work order update		nitial	Ad	ction		Sign &	•		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	g Description			Date	Verification		QC Inspector
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	Crimp/Kink/Ripple/Wave					Burrs	\vdash	4	nspection Incomplete/Unqualified		_	Part Incorrect Part Lost/Missing		\dashv	Weld
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	Heat Treat				Cut Too Short	\vdash	Mislab	_			Power Loss/Surge		\neg_{c}	Other	
	Inspection Strip in Tube					Drawing	\vdash	Misrea]. 0.1.61 2033/	'b- [-10	
Marks/Chatter						Drill Holes		Off-set							
	Turning Sequence					Finish		4	Calibration						
	Wave/Twist in Tube					Fit/Function		Out of Sequence							



1	1	. •	
DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED 7	APPROVED.	DRAWING NO.	REV. A SHEET 2 OF 2
DATE 05.	.08.25	HANDLE & LOCK	SCALE (-DOWN ASS'Y 1:2



P/N	D2: CUT LENGHT	D3: HOLE SPACING				
D3451-1	10.25	9.200				
D3451-3	10.63	9.700				
D3451-5	8.00	7.100				
D3451-7	10.00	9.000				

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303 D3451-5 SUPERSEDES PREMIER P/N B67-43001-301 D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
2) PART IS SYMETRICAL ABOUT CENTER LINE.
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DQA:		Date:									TOAPT			
•			_			WORK ORDER NON-	-CC	NFO	RMANCE / U	PDATE				AEROSPACE
QA Closed:			Date:			Work Order update only								
						DISPOSITION								
Work Orde			·			Rework	Skid-tube Crosstube					Water Jet	Engineering	
Part N	JO					Scrap			Machining			Prod. Eng. Coor.		Quality
	-					Use-as-is			noforming	Finishing	┪		e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite			Supplier		1
	-													
Root					Desc	ription of work order update	ı	nitial	Ac	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description			Date	Verification	QC Inspector
Design											ł			
Doc/Data														
Equip/Tooling														
Handling/Pre									<u> </u>					
Material												•		
Operator														
Offset/Setup														
Process	_													
Supplier	Ш						ļ							
Training	Ш													
Transport	\square													
Unapproved			<u> </u>				<u> </u>							
						· · · · · · · · · · · · · · · · · · ·	FA	JLT CA	TEGORY					
Landi	_					General		 1:- <i>/</i> 5		Г		المستعدم المسا	:	Pressure/Forced
	Bending				-	Bend BOM/Route	-	Folio/Program				Outside Dimensions Over/Under tolerance		Set-up
	Centre Not Concentric					BOM/Route	\vdash	Grain Hardware					<u> </u>	Temperature/Cure
	Cracks Crimp/Kink/Ripple/Wave				Broken/Damage/Defect	\vdash		ŀ			Part Incorrect		Weld	
Crimp/Kink/Ripple/Wave					-	Burrs	\vdash	1		Incomplete/Unqualified s Incomplete/Unclear		Part Lost/Missing Part Moved		Wrong Stock Pulled
	Couffs				Contamination Countersink	-	4	gned/off center	· · · · · · · · · · · · · · · · · · ·					
	Crushing Heat Treat			Cut Too Short	\vdash	Mislabe		in center		Positioned Wrong Power Loss/Surge		Other		
	Inspection Strip in Tube				Drawing	\vdash	Misrea		L		I OMEL LOSS	Juige [Jones	
Marks/Chatter				Drill Holes	\vdash	Off-set								
	Turning Sequence				\vdash	Finish	-	4	Calibration					
	Wave/Twist in Tube					Fit/Function	\vdash	Out of Sequence						